

Work Order ID 67249

Monday, March 14, 2011 10:43:12 AM

Blue

Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date:

11/03/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

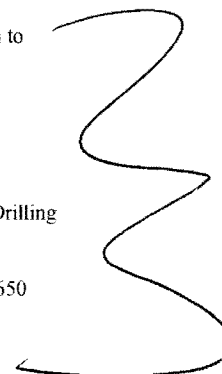
11-Deburr and Blow out all chips from inside the tube



11-3-16

BE 11-3-23

BE 11-3-23



BE 11/03-23

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Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u/03/25

⑩

116

QC10- Inspect visual per QSI004- ground welds 2.2, 0.00

0.00



QC

Memo

0.00

Quality Control

8 u/03/25

⑩

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

BB

4/03/28

Work Order ID 67249

Page 4

Monday, March 14, 2011 10:43:12 AM

Item ID: D206-642-441

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Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

11-3-29



QC

Memo

0.00

Quality Control

Work Order ID 67249

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

Memo1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐

Start Date: 11/03/31

Time: 11:00

☐

Finish Date: 11/03/31

Time: 11:30

A/R ☐ Sikaflex-291 ☐ 116040 ☐

Sikaflex expiry date: 11/09/30

3 BE 11/03/29

BB 11/03/31

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Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

Subtotal 5

80

160



Skidtube's

Skidtubes

Skidtubes

0.00

0.00

Memo

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod 07111385

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 11/10/14
BE 11/10/14

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Item ID: D206-642-441

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Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

BE 11/04/14

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

S 11/04/14

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 11/04/14

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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00							
Hand Finishing	Memo Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
205	Spray Painting per QSI005 4.2	0.00							
	SprayPaint	0.00							
Spray Painting	Memo Spray Painting: prime grey B: 117319 spray paint delfleet blue B: 115985 clear delfleet B: 117113								
220	QC- Inspect Part Finish	0.00							
	QC	0.00							
Quality Control	Memo								

225

QC14 Inspect Part
Permanent Change

18 11 04 270

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Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ M116040
Sikaflex expiry date: ☐ 1108

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

✓ A/R ☐ Sikaflex-291 ☐ M116040
Sikaflex expiry date: ☐ 1108✓ 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4
Batch: M1173751 0 21 04 27

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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-441								
	Location: _____								
	PPP Rev: <u>PPP 67249</u>								
260	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten: 11 04 28 ①

Handwritten: 11/03/11

Handwritten: nlskdj
mf
11-05-06

Picklist Print

Monday, March 14, 2011 10:43:07 AM

Page 1

Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube


Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620  Skidtube, 206 Skidtube		Manufactured	No			110	Each	15.0000	1	1			


Location Loc Qty Loc Code

LG 15
 62684 6
 64784 9

D2646  Aft Cap		Manufactured	No			110	Each	71.0000	1				
-------------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	---	--	--	--	--

Location Loc Qty Loc Code

FP-4 1
 57332 1
 FP6 16
 52663 3
 62678 12
 63633 1
 Return 2010 54
 62678 54

D2647  Cap		Manufactured	No			140	Each	51.0000	1	1			
-----------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

LG002 51
 55352 51

11-3-16
 Jd u/oc/27

9019
 1367265

3B 11/03/23

Picklist Print

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Page 2

Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-7 Manufactured No

160 Each

4.0000

1

1



Web

67601



1

BB 11/03/31

Location

Loc Qty

Loc Code

LG

4

67016

4

CCR264SS3-3

Purchased No

170 Each

332.0000

2

2



Cherry Rivet



BE 11/04/14

Location

Loc Qty

Loc Code

ST311

332

112314

4

113539

44

113973

88

117086

196

D2649

Manufactured No

170 Each

120.0000

23

23



Cross Bolt Spacer



BF 11/04/14
B 68224 * 23

Location

Loc Qty

Loc Code

LG001

120

58545

2

60652

4

61496

2

62889

11

63359

3

65317

98

D2680-041

Manufactured No

170 Each

14.0000

1

1



Nut Plate



BE 11/04/14

Location

Loc Qty

Loc Code

ST020

14

55366

14

Monday, March 14, 2011 10:43:07 AM

Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No

230 Each 626.0000 60 60



Insert



Handwritten: 11/04/27

Location

Loc Qty

Loc Code

PKG11

491

M117331

Handwritten: X60

114723

42

116864

449

ST281

135

110511

10

114654

39

115911

86

AN960JD10L NAS1149D0332J Purchased No

230 Each 4.0000 2 2



Washer

Handwritten: M117291



Handwritten: (x2) 11/04/27

Location

Loc Qty

Loc Code

ST335

4

11912

4

AN960JD416 NAS1149D0463J Purchased No

230 Each 30.0000 1 1



Washer



Handwritten: 11/04/27

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

Handwritten: M116805

Handwritten: 11

Picklist Print

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Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

230

Each

1,837.000

2

2



Cherry Rivet



BE 3/14/11

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

D2651-1

Manufactured

No

230

Each

571.0000

22

22



Plug



22 3/14/11

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

382

1367263

x22

53349

205

57869

117

66445

60

D2651-3

Manufactured

No

230

Each

404.0000

22

22



O-Ring



22 3/14/11

Location

Loc Qty

Loc Code

FP

404

46114

12

61962

392

x22

Picklist Print

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Work Order ID: 67249

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011



Required Date: 3/25/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-15 Manufactured No 230 Each 22.0000 1 1
  11/04/27
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	22	
63569	3	
<u>66238</u>	6	X \
66558	13	

D3535-23 Manufactured No 230 Each 18.0000 1 1
  11/04/27
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP021	18	
63571	4	
<u>66236</u>	13	X

D3535-37 Manufactured No 230 Each 7.0000 1 1
  11/04/27
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	7	
56101	1	
<u>62716</u>	6	X \

Picklist Print

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Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15

Manufactured No

230 Each

36.0000

1

1



Gasket



3/14/2011

Location

Loc Qty

Loc Code

FP

1

56055

1

FP011

34

63568

8

66559

26

FP11

1

59238

1

D3536-23

Manufactured No

230 Each

36.0000

1

1



Gasket



3/14/2011

Location

Loc Qty

Loc Code

FP

10

66240

10

FP011

26

63570

1

66560

25

D3536-37

Manufactured No

230 Each

24.0000

1

1



Gasket



3/14/2011

Location

Loc Qty

Loc Code

FP

24

63237

12

66823

12

Picklist Print

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Work Order ID: 67249

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1

 Wearpad

Manufactured No

230 Each

28.0000

6 6



Jul 11/04/27

Location

Loc Qty

Loc Code

FP017

28

1366935

X6

37749

5

65057

23

D3537-3

 Wearpad

Manufactured No

230 Each

20.0000

1 1



Jul 11/04/27

Location

Loc Qty

Loc Code

FP17

20

65929

20

X1

MS27039-1-08

 Screw

Purchased No

230 Each

1,059.000

2 2



Jul 11/04/25

Location

Loc Qty

Loc Code

ST291

1059

110835

319

X2

115108

740

MS27039-4-06

 Screw

Purchased No

230 Each

91.0000

1 1



Jul 11/04/27

Location

Loc Qty

Loc Code

ST292

91

109061

4

115460

87

X1

Picklist Print

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Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 3/14/2011

Required Date: 3/25/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

959.0000

60

60



SCREW



del. 11/04/27

Location

Loc Qty

Loc Code

FP

63

~~1117241~~

x60

115336

63

ST293

896

~~115589~~

347

x44

116022

148

x16

~~116373~~

400

19185

1

NAS1149C0332R

Purchased

No

230

Each

1,958.000

60

60



Washer



del. 11/04/27

Location

Loc Qty

Loc Code

ST297

1958

1117241

x60

115000

125

115698

35

116025

28

116304

1770

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67249

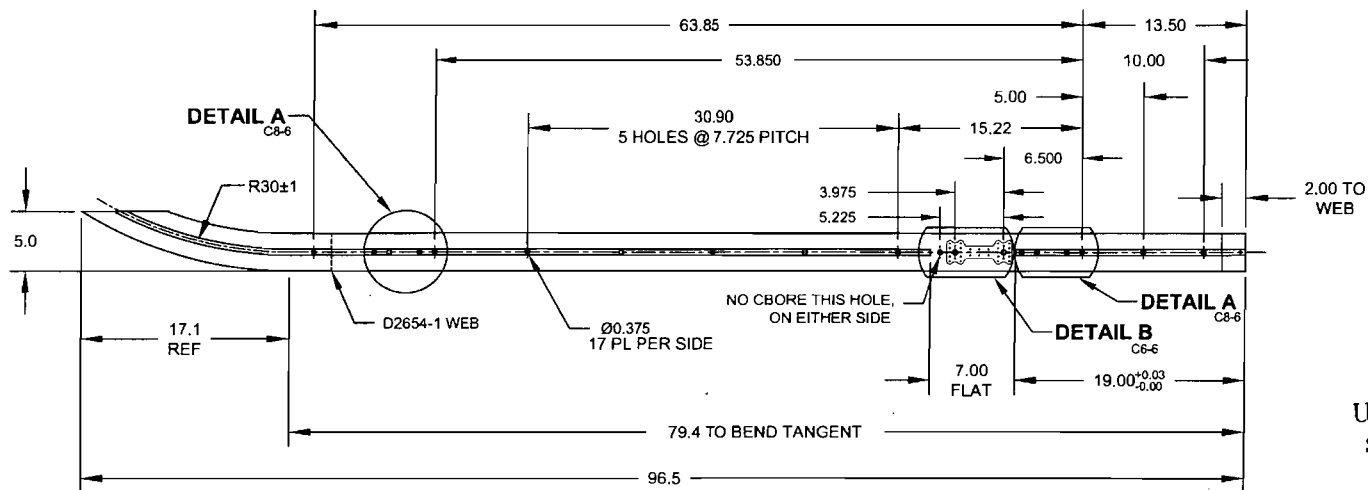
02/11/03/14

RELEASED
08-07-23/14

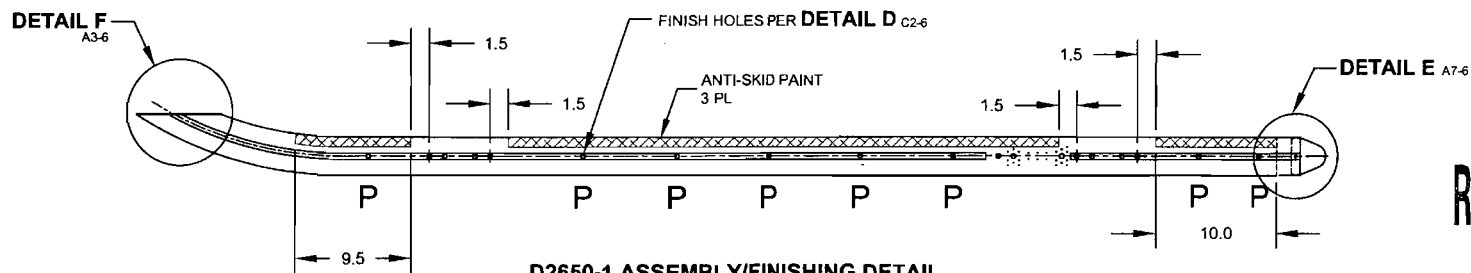
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 1 OF 6
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DE APPR.	J	206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-1 BENDING/DRILLING DETAIL

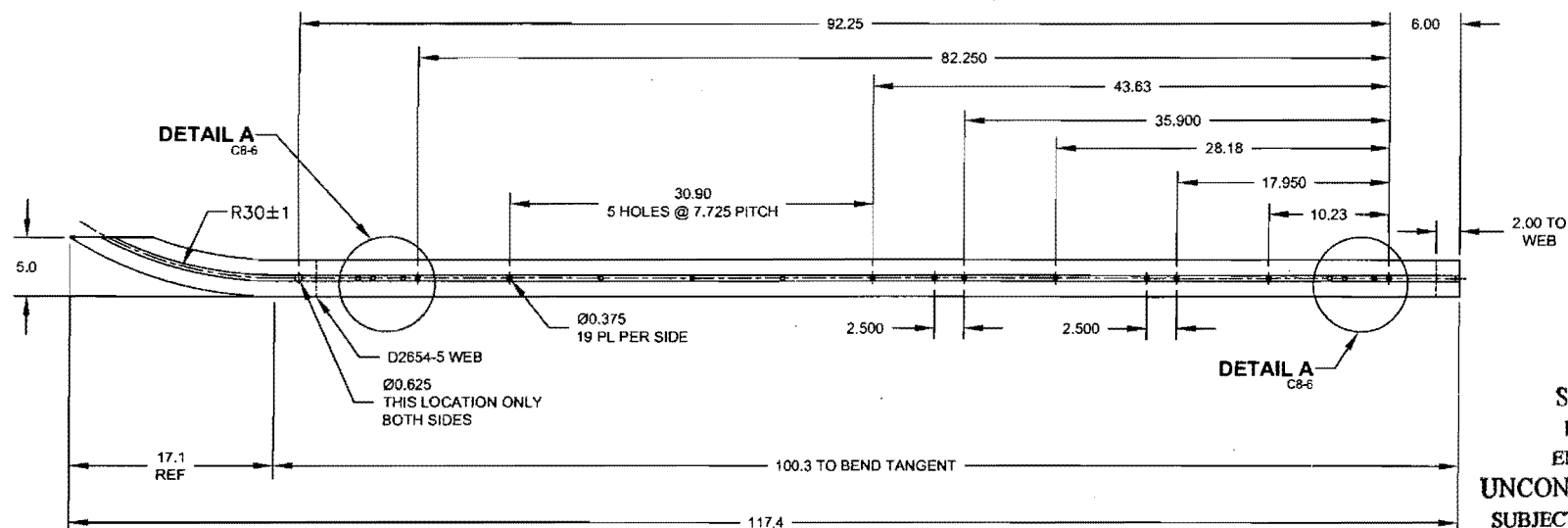


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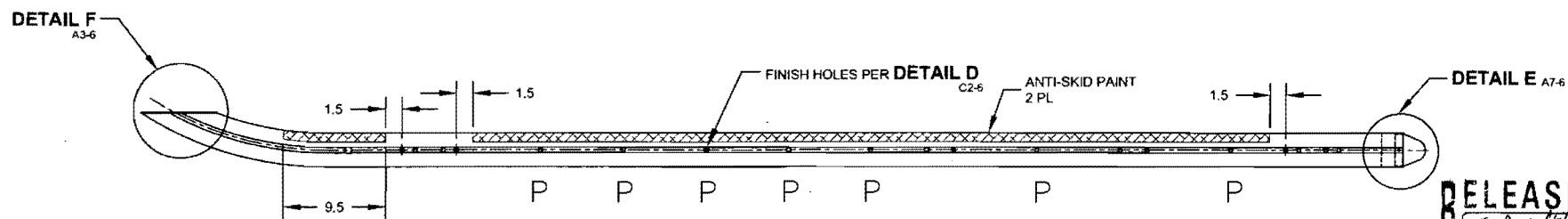
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



D2650-5 BENDING/DRILLING DETAIL

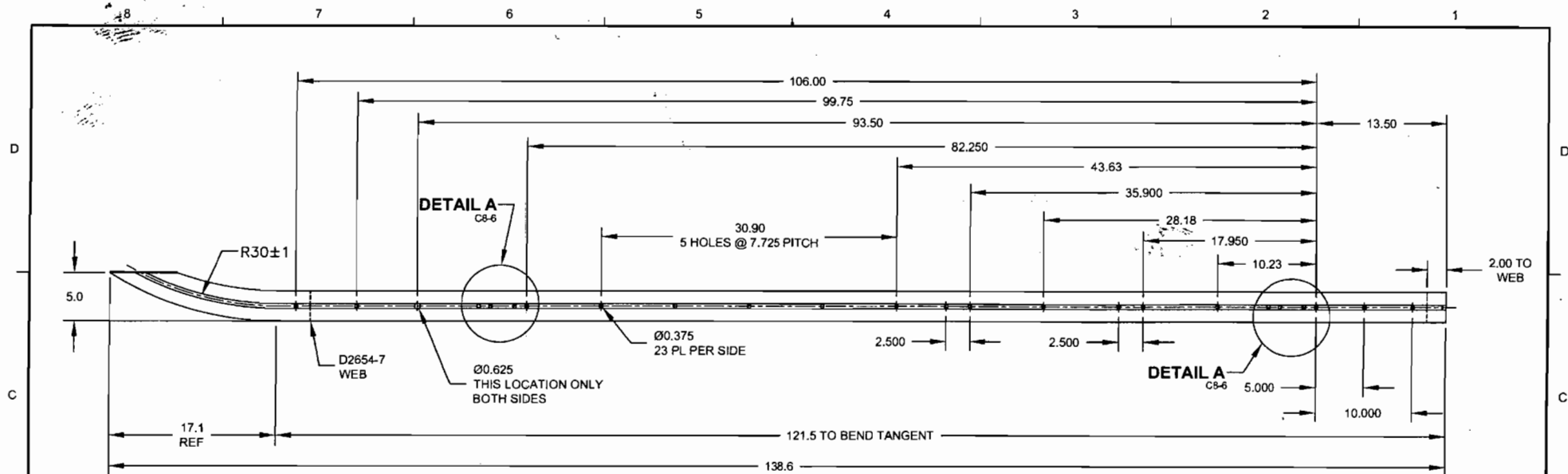
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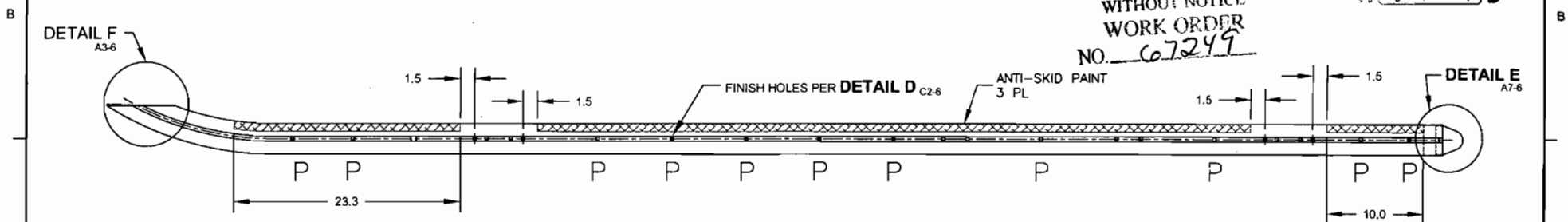
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D2650-7 BENDING/DRILL DETAIL

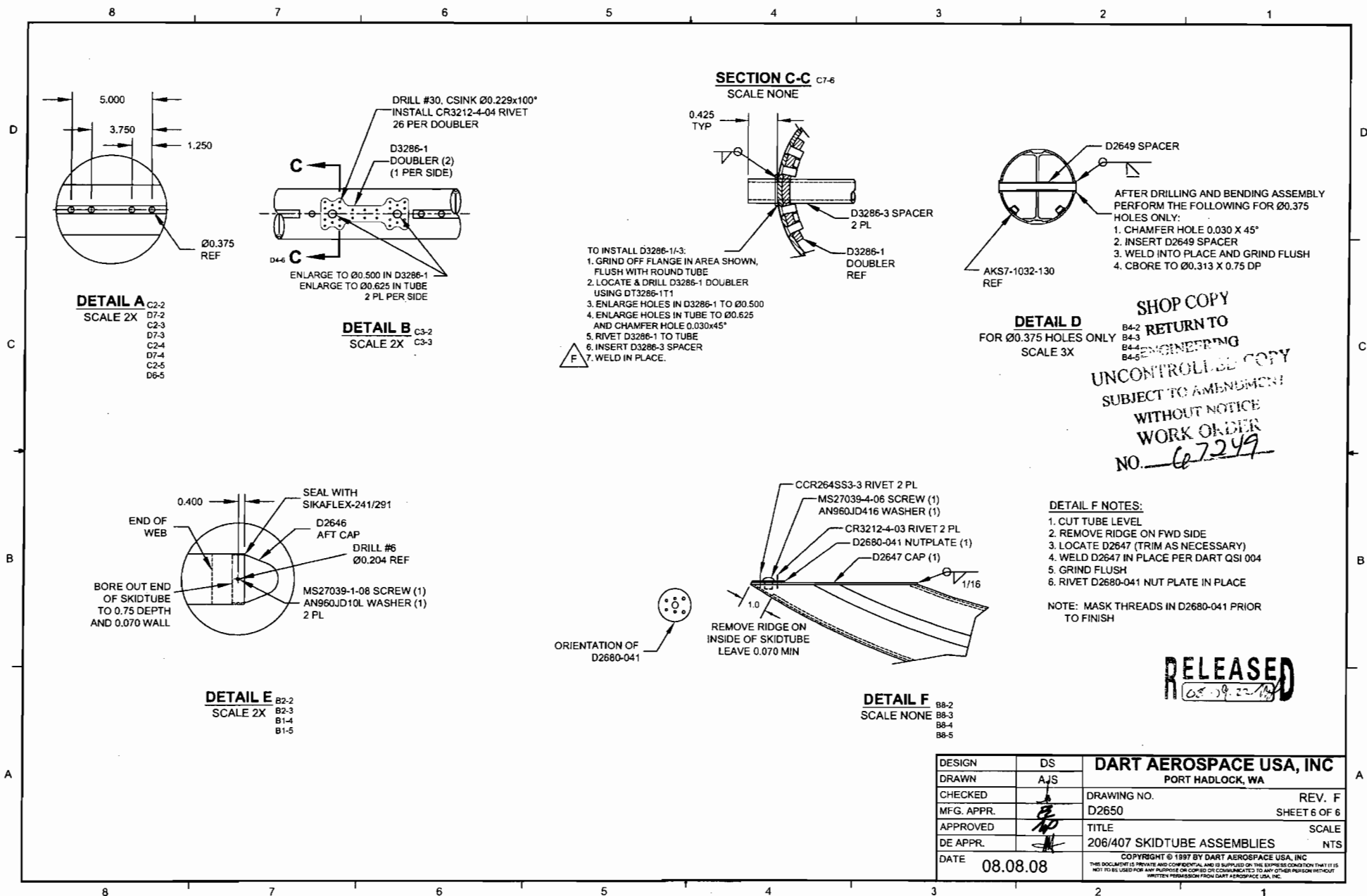
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NO. 246

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: 66462
Part number: D206-642-441
Description: 206 skirt tube
Welding Process: Tig[☒] Mig[]
Base material: 9/16 minimum
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Lums Date of Test Coupon 11-03-09
Welder Barkley Elliott Date of Test Coupon 11-03-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld